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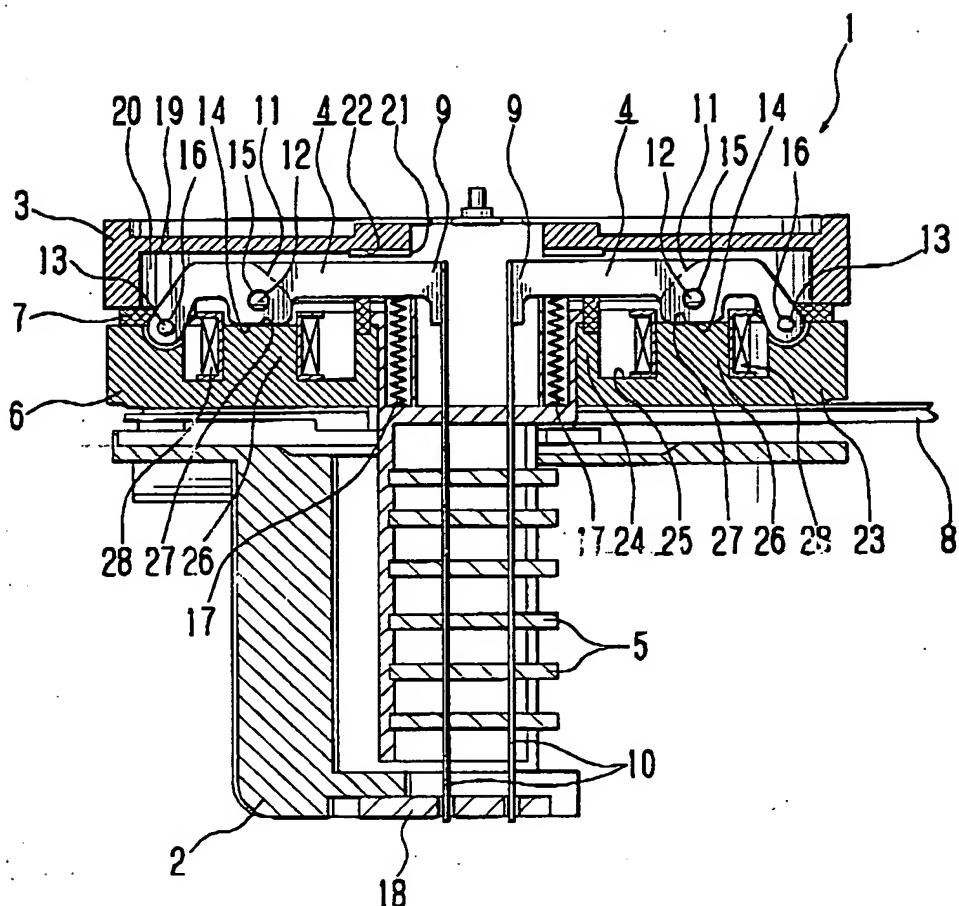
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Fig. 1



F i g . 2

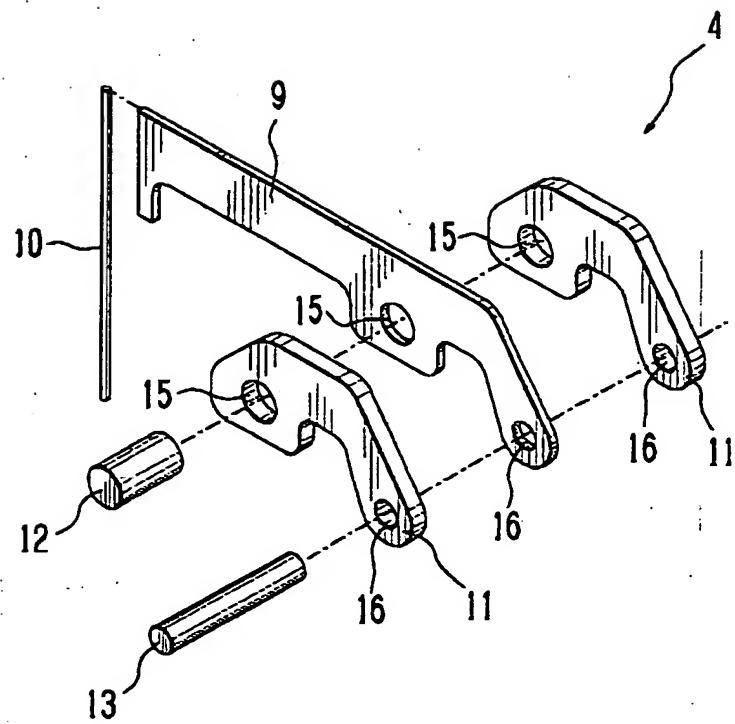


Fig. 3

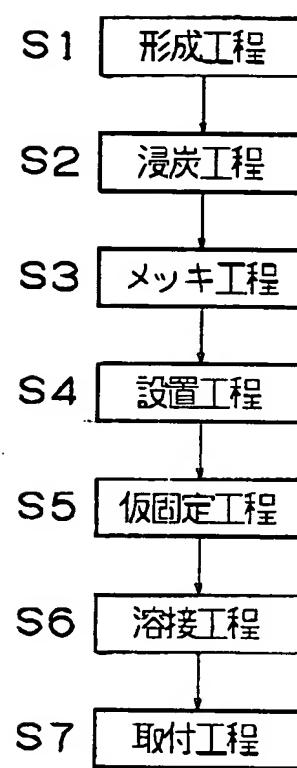


Fig. 4

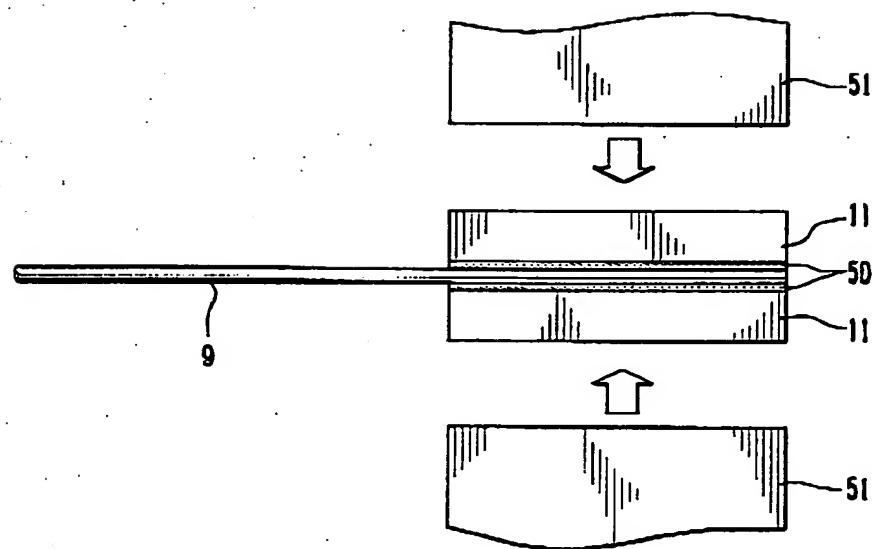


Fig. 5

	溶接電流(△)	加圧力(kgf)	電極先端直径(mm)	溶接電流波形	溶接強度(kgf·cm)
本実施例	3600	24	4×6	1+7+5+9+2	5.8
比較例	3750	24	4×6	1+7+5+9+6	5.5

Fig. 6A

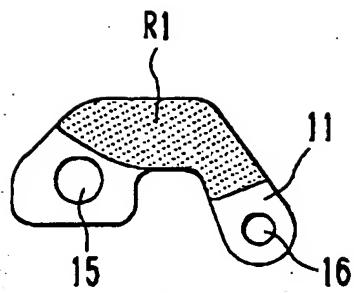


Fig. 6B

